

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004535**Date Inspected:** 06-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** C.M. Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

**OBG Assembly Bay 2**

A status sheet is being created for each floor beam segment in order to determine if green tagging can be performed or what discrepancies still exist and need completing before green tagging can be accomplished. The following is a list of items on the east segment:

**4BE – PP28**

FL2-1: One vertical stiffener needs to be fitted up and welded to Floor Beam.

FL2-2: The section of web plate removed for fit needs to be replaced and welded.

**4BE – PP 27**

FL2-1: Surface defects were observed on welds connecting vertical stiffeners to FL2-1

FL2-2: The section of web plate removed for fit needs to be replaced and welded.

**4BE – PP26**

FL2-1: Surface defects observed on welds connecting vertical stiffeners to FL2-1

FL2-2: The section of web plate removed for fit needs to be replaced and welded.

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## WELDING INSPECTION REPORT

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4AE – PP25

FL2-1 : One vertical stiffener needs to be fitted up and welded to Floor Beam.

FL2-2: The section of web plate removed for fit needs to be replaced and welded.

4AE – PP24

FL2-1 : Surface defects observed on welds connecting vertical stiffeners to FL2-1

FL2-2: The section of web plate removed for fit needs to be replaced and welded.

### Summary of Conversations:

No relevant conversations spoken on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Dautermann, Peter (707) 552-7715, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	McClendon,Timothy
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert
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QA Reviewer
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